

Date: Monday, 28/04/2008 8:13:36 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: FWD X-TUBE	
Job Number	: 38816		Part Number	: D2889	
Estimate Number	: 10006		Drawing Number	: D2889 REV B	
P.O. Number	:		Project Number	: N/A	
This Issue	: 28/04/2008 S.O. No. :		Drawing Revision	: B	
Prsht Rev.	: NC		Material	:	
First Issue	: / / Type : CROSSTUBES		Due Date	: 30/05/2008 Qty: 1 Um: Each	
Previous Run	: 38665				
Written By	:				
Checked & Approved By	: <u>JLDO8-4-28</u>				
Comment	: Est Rev:A New Issue 05-10-25 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6005180	Crosstube Material
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Crosstube material Pick: Qty Part number Description Batch 1 D2889 Fwd Crosstube <u>B34687</u>
2.0	BENDING	BENDING MACHINE - SKIDTUBES
		Comment: LANDING GEAR RESOURCE 1 1-Bend D2889 as per Dwg D2889 and Folio FT001
3.0	SKIDTUBES 1	SKIDTUBES RESOURCE 1
		Comment: LANDING GEAR RESOURCE 1 1-Deburr and Polish
4.0	QC15	DIMENSIONAL CHECK OF X-TUBES
		Comment: DIMENSIONAL CHECK OF X-TUBES
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		Comment: HAND FINISHING RESOURCE #1 Acid etch and alodine as per QSI 005 4.1 Inside and outside of tube

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
7.0	PACKAGING 1	PACKAGING RESOURCE #1 
<p>Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION</p> <p>Identify and Stock Location: _____</p> <p><i>work on 38813</i></p> <p><i>Coastal</i></p>		
8.0	QC21	FINAL INSPECTION/W/O RELEASE 
<p>Comment: FINAL INSPECTION/W/O RELEASE</p> <p><i>08/05/09 AF</i></p>		
Job Completion		 <i>MF 08-05-08</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

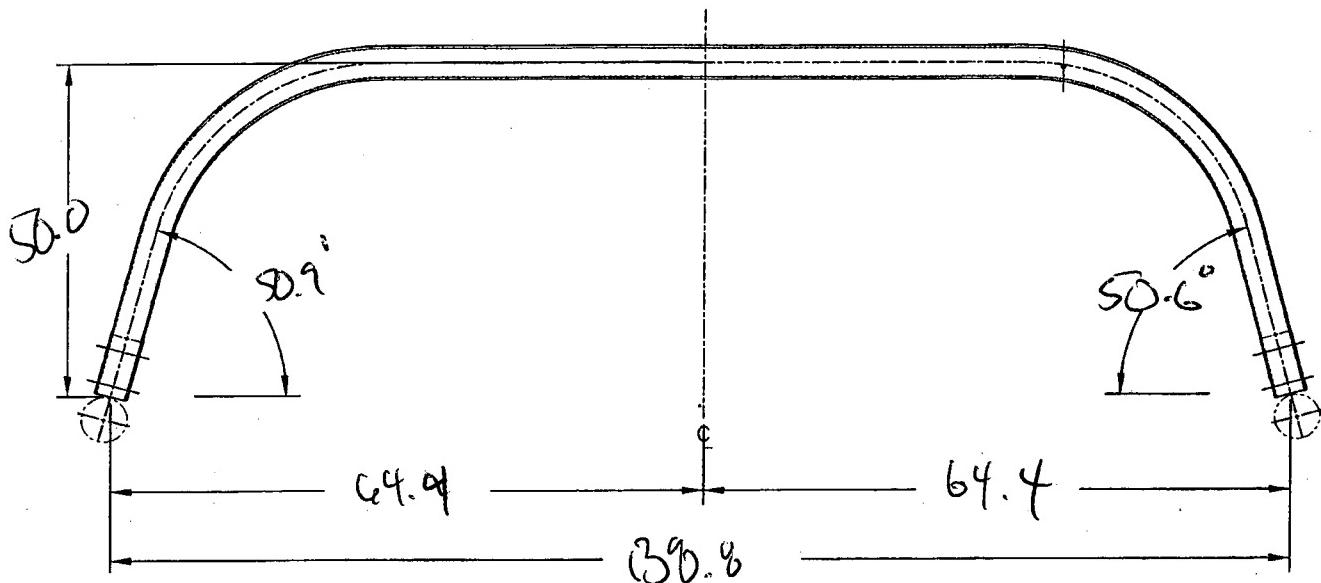
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

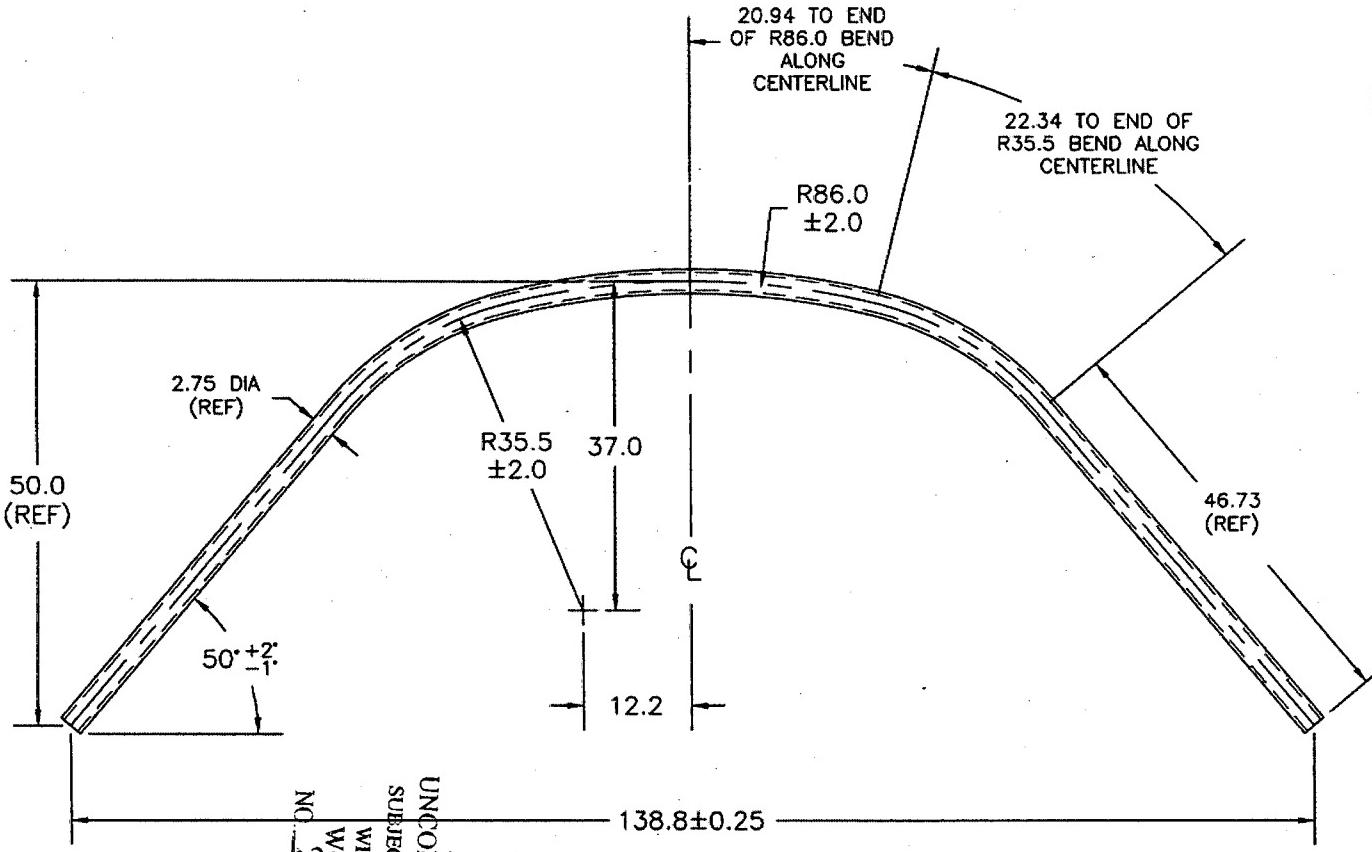
DART AEROSPACE LTD	Work Order:	38816
Description: Crosstube Fwd	Part Number:	D2889
Inspection Dwg: D2889	Rev: B	Page 1 of 1

Required Dimension	Min	Max
Height	49.875	50.125
1/2 Span	69.275	69.525
Angle	49	52
Total Span	138.55	139.05



Comments	
used on B& 38913	
QC15 Inspection	S
Date	08/08/01

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	JM



NOTES

- 1) MATERIAL: MANUFACTURE FROM D6005-180 ($\phi 2.75$ OD x 0.375 WALL)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BEND PROGRESSIVELY WITH MINIMUM OF 3 PASSES
- 6) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38816

RELEASED
02.10.28

DESIGN	DRAWN BY	DART AEROSPACE LTD	
	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D2889	SHEET 1 OF 1
DATE	TITLE	SCALE	
02.10.18	FWD CROSSTUBE	1:20	
A	99.05.21	NEW ISSUE	
B	02.10.18	ADD TANGENT LENGTHS; CHANGE NOTES	

6/2002
G. COOK
DRAFTS